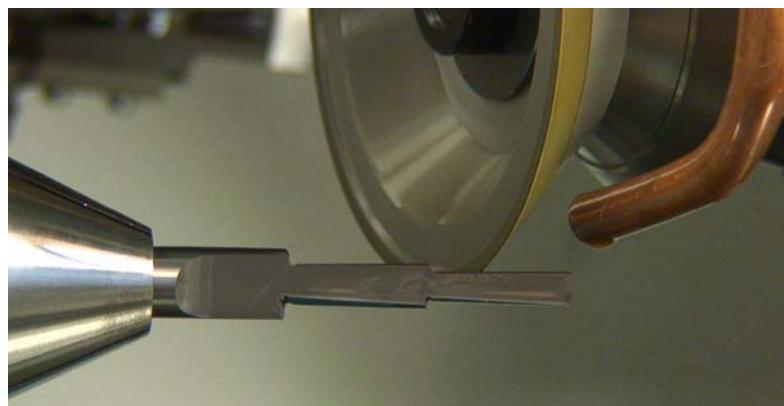


Spear Drill Ø14 L73mm

A06-110

L'utensile è ricavato da un cilindretto di metallo duro. Viene prima di tutto sgrossato a tuffo e poi rettificato nei diametri. Viene in seguito sgrossata la lancia con mola 1A1 e finita con una mola a tazza di grana molto fine. Viene profilata secondo il disegno dxf del cliente e grazie al software QUINTO dxQ, viene lasciata in automatico il tratto cilindrico richiesto e precedentemente rettificato. Completa la lavorazione l'affilatura della testa.



1. Cycletime for Production

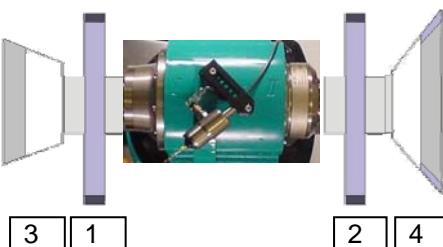
Workpiece:

Diameter 14 mm, Z 2, Length of cutting edge 73 mm, AXIAL

Material HM

Operations	Dia Roug	Dia Fin	Spear Rou	Spear Fin	Profil 1	Profil 2	Face 1	Face 2	Gashing
Feed [mm/Min]	1200	60	50	100	70	70	80	80	60
Power [kW]	2	1	1	1	1	1	1	1	1
Cutting feed [m/s]	24	30	24	24	30	30	30	30	20
Used wheels	1	2	2	3	4	4	4	4	4
Grinding time [s]	600	460	900	180	100	100	40	40	20
Total cycle time	40 Min 40								

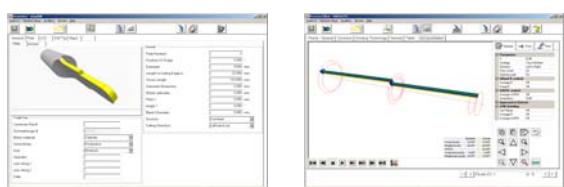
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1	1A1 Ø150 D76
2	1A1 Ø125 D64
3	11V9 Ø100 D46
4	12V9 Ø125 D64

3. Machine and Software Requirements



Machines: 5 axes CNC grinders : **NORMAcfg - GEMINIdmr AWL**

Control: Fanuc 160i

Coolant: Synthetic Oil, pressure 6 - 7 bar

Software: Quinto 5, DXQ

Engineer: A.Savoia, 20.10.2009

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TECHNOLOGY
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